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**D4635-141**  
**Job Sheet 201708**



**Part No:** D4635-141

**Job Qty:** 1 pcs

**Part Name:** Fwd Ceiling Replacement Panel Assembly, LH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/9/19

**Job Tracking No:**

**Due Date:** 11/15/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG D4635 REV.G SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver:DD IPP Rev D Dwg Update 13/12/09 DL lpp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL IPP REV:G 19.05.14 AS PER DWG REV.G DD VERF:DP

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Lead Time |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |           |
| 110   | Small Fab - 1               | 1 pcs | 11/15/19   |          | 0.00      | 1.47    | Small Fab - 1         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 8         |           |           |
| 120   | QC 5                        | 1 pcs | 11/15/19   |          | 0.00      | 0.00    | QC 5 - 10             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |           |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |           |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 40             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 61             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 81             |           |           |
| 130   | Packaging 3-1 - Stock - B4B | 1 pcs | 11/15/19   |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |           |

DAS Sign-off  
118 NOV 06 2019

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NOV 08 2019 9-59

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|                |       |          |           |                        |              |
|----------------|-------|----------|-----------|------------------------|--------------|
|                |       |          |           | Packaging 3 - 4 - B4B  |              |
|                |       |          |           | Packaging 3 - 5 - B4B  |              |
|                |       |          |           | Packaging 3 - 6 - B4B  |              |
|                |       |          |           | Packaging 3 - 7 - B4B  |              |
|                |       |          |           | Packaging 3 - 8 - B4B  | NOV 1 1 2019 |
|                |       |          |           | Packaging 3 - 9 - B4B  |              |
|                |       |          |           | Packaging 3 - 10 - B4B |              |
|                |       |          |           | Packaging 3 - 11 - B4B |              |
|                |       |          |           | Packaging 3 - 12 - B4B |              |
|                |       |          |           | Packaging 3 - 13 - B4B |              |
|                |       |          |           | Packaging 3 - 14 - B4B |              |
|                |       |          |           | Packaging 3 - 15 - B4B |              |
|                |       |          |           | Packaging 3 - 16 - B4B |              |
|                |       |          |           | Packaging 3 - 17 - B4B |              |
|                |       |          |           | Packaging 3 - 18 - B4B |              |
|                |       |          |           | Packaging 3 - 19 - B4B |              |
|                |       |          |           | Packaging 3 - 20 - B4B |              |
|                |       |          |           | Packaging 3 - 21 - B4B |              |
|                |       |          |           | Packaging 3 - 22 - B4B |              |
|                |       |          |           | Packaging 3 - 23 - B4B |              |
|                |       |          |           | Packaging 3 - 24 - B4B |              |
|                |       |          |           | Packaging 3 - 25 - B4B |              |
|                |       |          |           | Packaging 3 - 26 - B4B |              |
|                |       |          |           | Packaging 3 - 27 - B4B |              |
|                |       |          |           | Packaging 3 - 28 - B4B |              |
|                |       |          |           | Packaging 3 - 29 - B4B |              |
|                |       |          |           | Packaging 3 - 30 - B4B |              |
|                |       |          |           | Packaging 3 - 31 - B4B |              |
|                |       |          |           | Packaging 3 - 32 - B4B |              |
|                |       |          |           | Packaging 3 - 33 - B4B |              |
|                |       |          |           | Packaging 3 - 34 - B4B |              |
|                |       |          |           | Packaging 3 - 35 - B4B |              |
|                |       |          |           | Packaging 3 - 36 - B4B |              |
| 140 QC 21 - SA | 1 pcs | 11/15/19 | 0.00 0.00 | QC 21 - SA - 21        |              |
|                |       |          |           | QC 21 - SA - 70        |              |
|                |       |          |           | QC 21 - SA - 53        | NOV 1 1 2019 |

Part Op 110 - (Small Fab) Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300  
 Descriptions: Batch: 521465 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 5159491 Expiry Date 02/01/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m128191  
 120 - QC5- Inspect part completeness to step on W/O  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_) Identify as per dwg & Stock Location: \_\_\_\_\_  
 140 - QC21- Final Inspection - Work Order Release

012743

## Job BOM

| Part / Item   | Component Name        | Quantity     | Operation         | Container |
|---------------|-----------------------|--------------|-------------------|-----------|
| D4635-1       | Fwd Ceiling Panel, LH | 1 pcs (1 ea) | 110-Small Fab - 1 | 5134135   |
| D4669-1       | Bracket               | 2 pcs (2 ea) | 110-Small Fab - 1 | 5122038   |
| D4695-041     | Channel Assembly, LH  | 1 pcs (1 ea) | 110-Small Fab - 1 | 5025501   |
| D4732-29      | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 | 5224588   |
| D4732-33      | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 | 5060906   |
| D4732-5       | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 | 5060906   |
| D4732-9       | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 | 5060906   |
| D5022-1       | Foam, Side Panel, Fwd | 1 pcs (1 ea) | 110-Small Fab - 1 | 5060906   |
| MPNY-750S-9-C | Mounting Pad          | 7 pcs (7 ea) | 110-Small Fab - 1 | 5060906   |

522465  
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| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Small Fab - 1                  | D4635-1        | 1        | 3         | 0         |
|                                    | D4669-1        | 2        | 21        | 0         |
|                                    | D4695-041      | 1        | 3         | 0         |
|                                    | D4732-29       | 1        | 15        | 0         |
|                                    | D4732-33       | 1        | 15        | 0         |
|                                    | D4732-5        | 1        | 15        | 0         |
|                                    | D4732-9        | 1        | 25        | 0         |
|                                    | D5022-1        | 1        | 7         | 0         |
|                                    | MPNY-750S-9-C  | 7        | 104       | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. \_\_\_\_\_

Job: \_\_\_\_\_

Part No. \_\_\_\_\_

### DISPOSITION

Rework ☐ ☐ ☐  
Scrap ☐ ☐ ☐  
Use-as-is ☐ ☐ ☐

### DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐  
Small Fab ☐ ☐ ☐  
Finishing ☐ ☐ ☐  
Skid-tube ☐ ☐ ☐  
Machining ☐ ☐ ☐  
Large Fab ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐  
Prod. Eng. Coord. ☐ ☐ ☐  
Rec/Store/Packaging ☐ ☐ ☐  
Engineering ☐ ☐ ☐  
Water Jet ☐ ☐ ☐  
Supplier ☐ ☐ ☐  
Quality ☐ ☐ ☐

Date: \_\_\_\_\_

Sequence #: \_\_\_\_\_

QTY Affected: \_\_\_\_\_

MRB (QSI042)

### Description Work Order Deviation

### Disposition

Completed By \_\_\_\_\_

Lead hand / Supervisor \_\_\_\_\_

QC / QA Coordinator \_\_\_\_\_

### Root Cause

Operator ☐ ☐ ☐  
Manufacturing Process ☐ ☐ ☐  
Equip/Tooling ☐ ☐ ☐  
Handling/Preservation ☐ ☐ ☐  
Material ☐ ☐ ☐  
Product Improvement ☐ ☐ ☐  
Process Improvement ☐ ☐ ☐  
Human Factors ☐ ☐ ☐

### FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐  
Bending ☐ ☐ ☐  
Crushing ☐ ☐ ☐  
Cracks ☐ ☐ ☐  
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐  
Marks/Chatter ☐ ☐ ☐  
Mislabeled ☐ ☐ ☐  
Contamination ☐ ☐ ☐  
Misaligned/off center ☐ ☐ ☐  
BOM/Route ☐ ☐ ☐  
Broken/Damage/Defect ☐ ☐ ☐  
Incomplete/Unclear Instructions ☐ ☐ ☐  
Drill Holes ☐ ☐ ☐  
Fit/Function ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐  
Folio/Program ☐ ☐ ☐  
Grain Direction ☐ ☐ ☐  
Weld ☐ ☐ ☐  
Wrong Stock Pulled ☐ ☐ ☐  
Out of Sequence ☐ ☐ ☐  
Off-set/Set-up ☐ ☐ ☐  
Positioned Wrong ☐ ☐ ☐  
Outside Tolerance ☐ ☐ ☐  
Drawing ☐ ☐ ☐  
Finish ☐ ☐ ☐  
Part Lost/Missing ☐ ☐ ☐  
Misread ☐ ☐ ☐

Other/Details: \_\_\_\_\_